

Shp Tues latest April 1 5

Work Order ID 115408

March 31-14 9:23:13 AM

\*115408\*

Page 1

Item ID: D4542-5

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Retainer, Inner

Start Date: 3/31/14

Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 4/01/14

Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4542

E - CUSTOM

100

0.00

\*100\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

1- Cut as per dwg

Prog rev: E - custom

Dwg rev: E - custom

2- Deburr

4

0

Jm14-03-31

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

4

0

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Item ID: D4542-5 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Retainer, Inner  
 Start Date: 3/31/14 Start Qty: 12.00 \*12\* Cust Item ID:  
 Required Date: 4/01/14 Req'd Qty: 12.00 \*12\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 DAS 27 1-89 4/3/31				4			
125 *125* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				4	2/14-3-31		
127 *127* QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00 0.00 DAS 27 1-89 4/3/31				4			

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**\*115408\***

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Item ID:	D4542-5	Accept	<b>*N900040100*</b>	Setup	Start	<b>*NS1*</b>
Revision ID:					Stop	<b>*NS2*</b>
Item Name:	Retainer, Inner					
Start Date:	3/31/14	Start Qty:	12.00	<b>*12*</b>	Cust Item ID:	
Required Date:	4/01/14	Req'd Qty:	12.00	<b>*12*</b>	Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

14/3/31

MLJ 14-03-31

14.03.31

# Picklist Print

March-31-14 9:23:13 AM

Page 1

Work Order ID: 115408

\*115408\*

Parent Item: D4542-5

\*D4542-5\*

Parent Item Name: Retainer, Inner

Start Date: 3/31/14

Required Date: 4/01/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B  
12.02.24 as per dwg reva DD verf:EC IPP REV:C 12.05.08 as  
per dwg revB DD verf:EC IPP REV:D 13.04.23 as per dwg revD  
DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	317.3832	0.208	③			
*M6061T6S 0.32*										**		Jm14-03-31	
6061-T6 Sheet 0.032"													

Location

Loc Qty

Loc Code

MAT021

317.38317

123483

8.57

m125822

17

m127272

119.43317

m128054

172.38

128054.



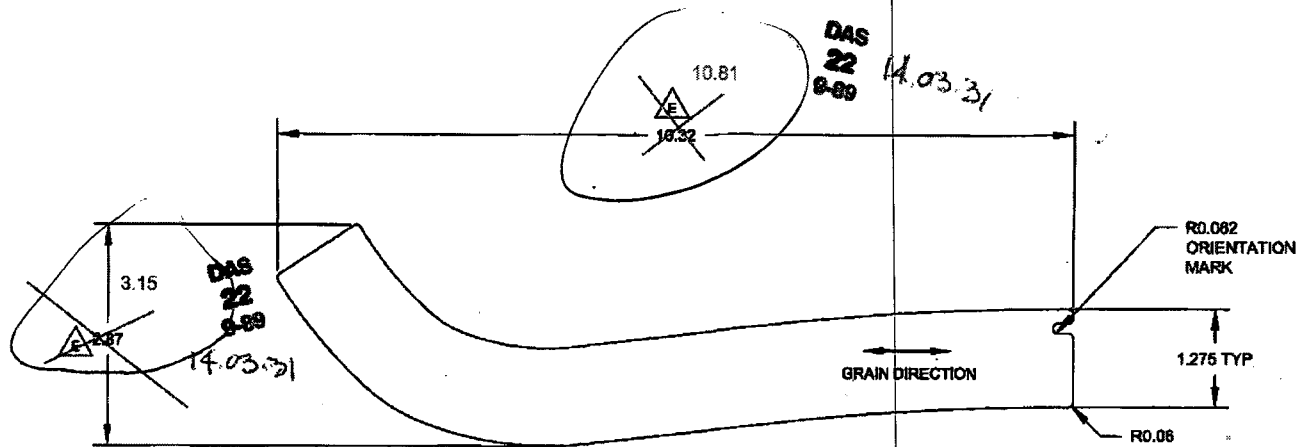
8 7 6 5 4 3 2 1

D

C

B

A



**D4542-5 RETAINER, INNER**  
(TOP CORNER)

W/O 115408

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) PROFILE PER DRAWING FILE "D4542-5-REVE.DXF"

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4542	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
DATE	14.03.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1